

Date: Friday, 09/01/2009 11:20:18 AM  
 User: Chantal Lavoie

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LUG EXTRUSION  
 Job Number : 44529  
 Estimate Number : 10305  
 P.O. Number :  
 This Issue : 09/01/2009 S.O. No. :  
 Prsht Rev. : NC Part Number : D2423  
 Drawing Number : D2423 REV B1  
 Project Number : N/A  
 Drawing Revision : B1  
 First Issue : / / Type : PURCHASED PARTS  
 Material :  
 Due Date : 24/01/2009 Qty: 30 Um: Each  
 Previous Run : 43722  
 Written By :  
 Checked & Approved By : C 209/01/09  
 Comment : Est G 04.09.02 Part Number D2423-108 changed to D2423KJ/J LM

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
2.0	D2423P	Lug Extrusion
Comment: Qty.: 1.0000 f(s)/Unit Total : 30.0000 f(s) Lug Extrusion		
3.0	PACKAGING 1	PACKAGING RESOURCE #1
4.0	QC6	DIMENSIONAL CHECK
5.0	PACKAGING 1	PACKAGING RESOURCE #1
6.0	QC21	FINAL INSPECTION/W/O RELEASE



P/O: 7937 C 209/01/09 30ft



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 09-01-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

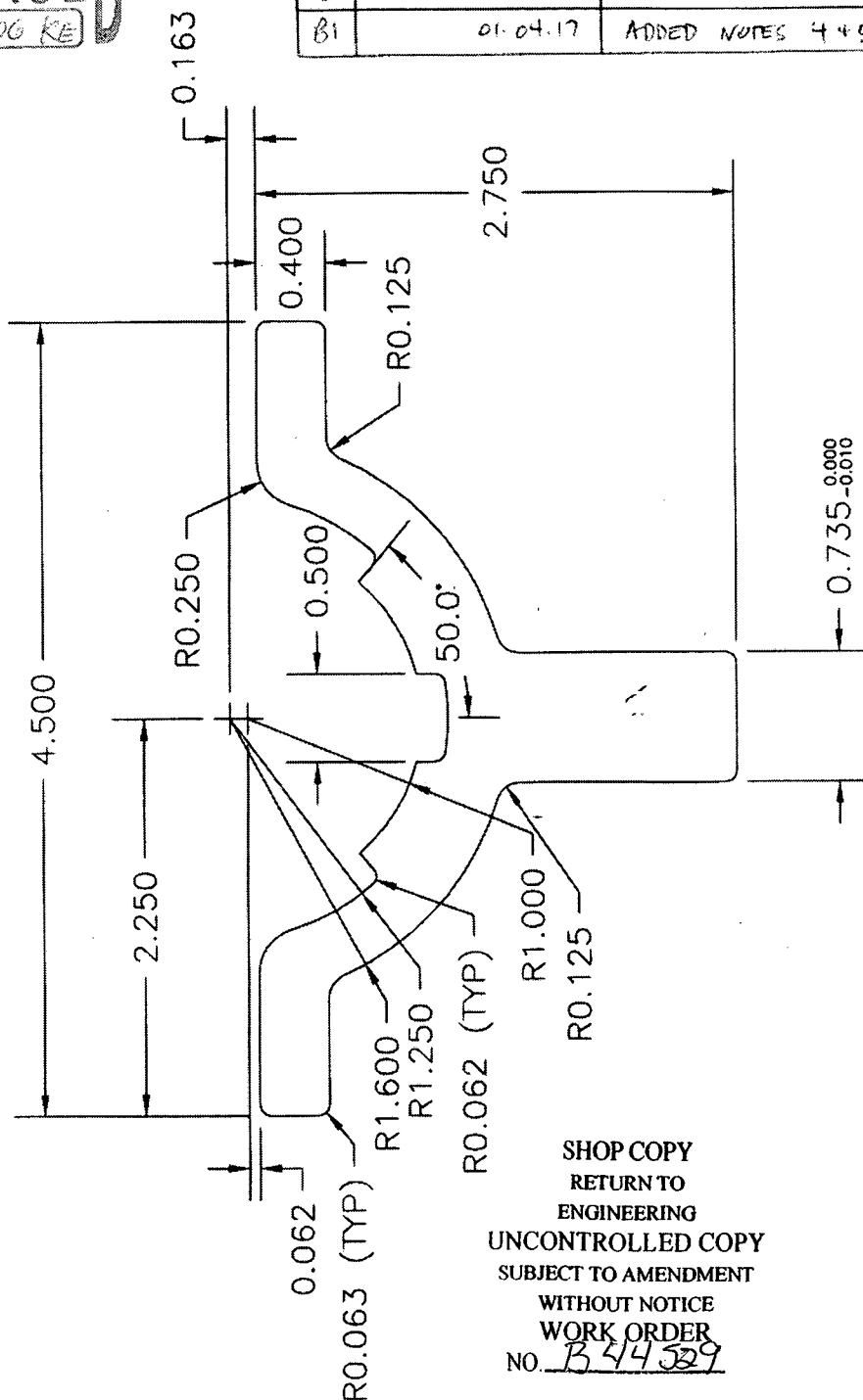
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN. <i>KE</i>		DRAWN BY <i>KE</i>		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>W</i>		APPROVED <i>SE</i>		DRAWING NO. D2423 REV. B SHEET 1 OF 1	
DATE 98.08.04		TITLE LUG EXTRUSION SCALE 1:1			
A	95.05.09	NEW ISSUE			
B	98.08.04	6061-T6 WAS 6005A.T5			
Bi	01.04.17	ADDED NOTES 4 & 5 <i># CP</i>			

RELEASED  
93/04/06 RE



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. B 44529

1. MATERIAL: 6061-T6 ALUMINUM (QQ-A-200/8)
2. NOTE: ALL DIMENSIONS ARE IN INCHES
3. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4. MANUFACTURED USING CARBON INFLEX DIE # MS-12866
5. PART NUMBER IS D2423-XXX WHERE XXX IS CUT LENGTH IN INCHES (E.G. D2423-108 IS 108" LONG)



INVOICING COMPANY AND LOCATION  
SIGNATURE ALUMINUM CANADA  
1850 CLEMENTS ROAD  
PICKERING ON L1W 3R8

# SHIPPING MANIFEST

ACCT# 00046024

SHIP TO DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY ON K6A 1K7 CN  PHONE 613-632-5200	SOLD TO / PURCHASER DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY ON K6A 1K7 CN  PHONE 613-632-5200
--	--

TERMS / FREIGHT  
O / P

REFER TO  
THESE NUMBERS ON  
ALL CORRESPONDENCE

MANIFEST DATE 01-20-09
MANIFEST NUMBER 653468
SALES ORDER NUMBER 42092

CREDIT REP HAMBROOK, PAU 905-508-3250	SALES REP
FIELD SALES REP Kutter A 450-435-6551	CUST SERVICE REP Burton D 905-427-2227

CUSTOMER ID 46024	ORDER DATE 01/09/09	CUSTOMER PO NUMBER 7937	JOB	BILL OF LADING NUMBER 08387779
----------------------	------------------------	----------------------------	-----	-----------------------------------

ITEM NO.	ORIGINAL ORDER QUANTITY	UNIT	PREVIOUS SHIPPED QUANTITY	MFG. PART NUMBER	ALLOY & TEMPER	FINISH DESCRIPTION	THIS SHIPMENT			UNIT	QUANTITY DUE	
				CUSTOMER PART NUMBER	LENGTH	FABRICATION DESCRIPTION	NBR OF PKGS	GROSS POUNDS	NET QUANTITY			
					CUTTING TOLERANCE	SHIPPING TOLERANCE						
01	3	KG	0	DAA-5-1	6061 /T6	MILL	1	89	85	KG	0	
		M	0	D2423P	10'	CERTIFICATE OF COMP			15.24	M	0	
		PC	0		+3/16 "	(+050-050,0004-0001)			5	PC	0	
				This is the 1st sample order - ensure all dimensions are within tolerances. Must be packaged with paper interleave and cardboard all around.								
				LOT/TKT DETAIL:		42092010 / 299985	1	89	85		5 PC	

Transportation/Traffic damages and/or shortage claims are to be noted on the delivery copy of sellers shipping manifests and signed and dated below by customers authorized representatives.  
No return materials will be accepted for credit without permission. The articles and/or services covered by this shipping manifest were produced in accordance with the fair labor standards act of 1938 as amended. Order accepted subject to the terms and conditions stated on the reverse side.

PAGE 1

1	89	85	KG
		15.24	M
		5	PC
TOTALS			

EXTMAN2 CUSTOMER ACKNOWLEDGEMENTS DELIVERED AND CONDITION

DATE OF DELIVERY

DRIVER

# CERTIFICATE OF COMPLIANCE

## SIGNATURE ALUMINUM CANADA

1850 CLEMENTS ROAD  
PICKERING, ON L1W 3R8

Cert Date	Cert No	Sales Order	Page
01/20/09	186240	42092	1
Cust PO	B/L No	Lot	Date
7937	08387779	42092010	1/20/09

Sold To	Ship To
46024	46024
DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7	DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7

Item No	Part No	Item Description	Cust Part
1.000	DAA-5-1	10' MILL 6061 T6	D2423P
Gross Weight	89 KGS		
Net Qty	85 KG	5 PC	15 M 1 PKG
Specification	Die Desc		
ASTM B221-08			

Mechanical Tests:

Test No.	Tensile MPA / KSI	Yield MPA / KSI	%Elongation	Conductivity	Bend/ Drift HREW
1	349.3 / 50.7	324.6 / 47.1	14.7	.0	91

### Chemical Analysis:

SI	FE	CU	MN	MG	CR	ZN	TI
.67	.25	.28	.06	.91	.05	.05	.02

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgment form. No other warranties are applicable.

Conchita Ko, QA Manager Signature Aluminum Canada Inc

*Handwritten signature: Conchita Ko.*

*Handwritten initials: GK, CP, 09.01.23*